

Rush Sent Jan 3, 2017

Work Order ID 154538***154538***

Page 1

Thursday, December 15, 2016 8:01:00 AM

Item ID: D3876-9 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Protector - RH Aft Wall
Start Date: 12/12/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 12/15/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** DAS 21 **Date:** DEC 15 2016 **Tooling:** **Date:** **Run** **Start** ***NR1***
QC: 9-89 **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3876	A							DAS 46 9-89	16/12/21
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.12							
FLOW CNC Waterjet	1-Cut as per Dwg D3876 Dwg Rev: <u>A</u> Prog Rev: <u>1</u> 2- Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB							DAS 46 9-89	16/12/21
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control								DAS 9 9-89	16-12-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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154538

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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

Identify as per dwg & Stock Location OK

0.00

130

Packaging

Memo

0.00

Packaging

/

DAS
6
9-89

JAN 03 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

DAS
21
9-89

JAN 06 2017

DAS
21
9-89

JAN 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Thursday, December 15, 2016 8:01:00 AM

Work Order ID: 154538

154538

Parent Item: D3876-9

D3876-9

Parent Item Name: Protector - RH Aft Wall

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-14 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04

Purchased

No

100

sf

4,547.982

3.08

3.623529

DAS
46
9-89

16/12/21

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET (DARK GREY)

Location

Loc Qty

Loc Code

MAT018

4547.982353

m135074

803.482353

m136228

3744.5

6

DQA: _____ Date: _____

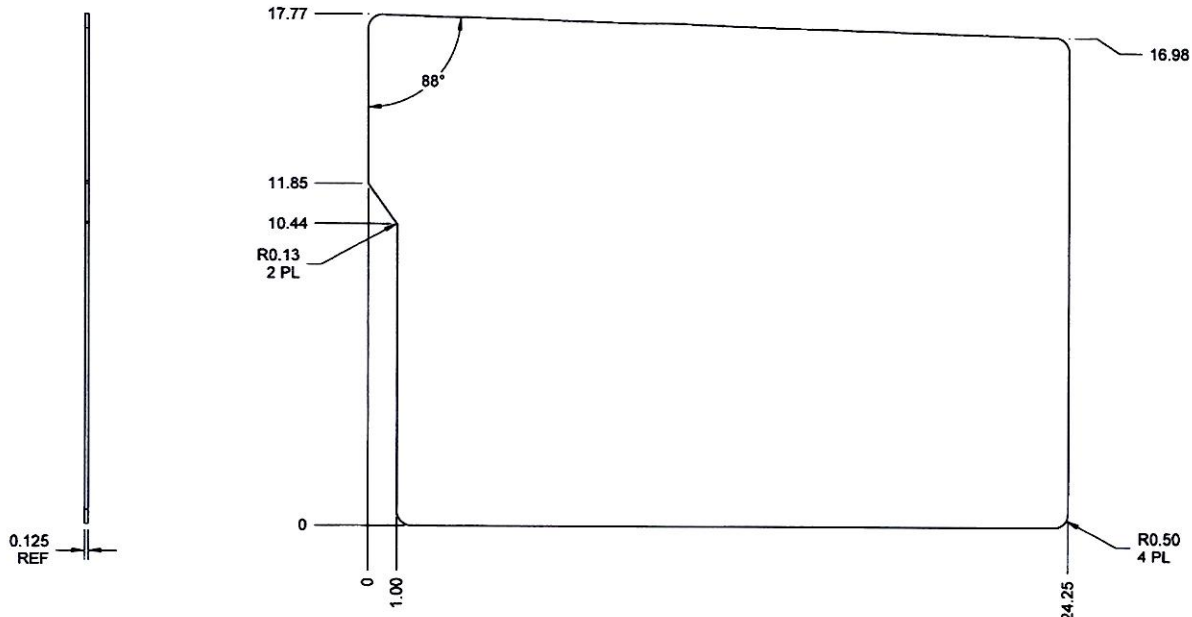


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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154538
ML5
16-12-15

RELEASED
20/12/03 MB

D3876-9 PROTECTOR - RH AFT WALL
(TEXTURED SIDE SHOWN)

NOTES:

- 1) MATERIAL: F80029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F80029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-9" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 2.22 lbs
- 8) CHECK PER TEMPLATE DT8928

DESIGN	ES	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ES		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	FE	D3876	SHEET 5 OF 7
APPROVED	MD	TITLE	SCALE
DE APPR.	TH	BAGGAGE PROTECTOR	NTS
DATE	09.04.02	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	